

Work Order ID 101981

May-22-13 7:18:51 AM

*Block Smiley*

\*101981\*

Page 1

Item ID: D3913-041

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Long Basket Base Assemby, 350

Stop

\*NS2\*

Start Date: 5/22/13

Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 6/06/13

Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr Revision Nbr

D3913

B

D4020

A

100

Weld per dwg A/R S.S. rod Batch: *1128357* 0.00

\*100\*

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A

\*\*\*inspect before welding mesh\*\*\*

2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913  
and trim mesh to fit if necessary and trim to clear fasteners holes on the ends

3-weld hinge (3) and Mounting brackets as per dwg D3913  
\*\*\*take lid to locate hinge and bracket\*\*\*

4- Weld D4672-1 blanking plates as per dwg

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

\*110\*

QC

Quality Control

Memo

0.00

*13-05-27*

*DAS  
09  
8-89*

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**Item ID:** D3913-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

**Revision ID:**

Stop

**\*NS2\***

**Item Name:** Long Basket Base Assemby, 350

**Start Date:** 5/22/13    **Start Qty:** 1.00

**\*1\***

**Cust Item ID:**

**Required Date:** 6/06/13    **Req'd Qty:** 1.00

**\*1\***

**Customer:**

**Reference:**

Run Start

**\*NR1\***

**Approvals:** Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

**Sequence ID/  
Work Center ID**

**Operation  
Description**

**Set Up/  
Run Hours**

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

13-05-27

DAS  
09  
09

**\*120\***

QC

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

16 Bk B527.

**\*125\***

HandFinish

Hand Finishing

Memo

0.00

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**Item ID:** D3913-041

Accept

\*N900040100\*

Setup

Start

\*NS1\*

**Revision ID:**

**Item Name:** Long Basket Base Assembly, 350

**Start Date:** 5/22/13    **Start Qty:** 1.00    **\*1\***

**Required Date:** 6/06/13    **Req'd Qty:** 1.00    **\*1\***

**Cust Item ID:**

**Customer:**

**Reference:**

Stop

\*NS2\*

<b>Approvals:</b>	<b>Process Plan:</b> _____	<b>Date:</b> _____	<b>Tooling:</b> _____	<b>Date:</b> _____	<b>Run</b>	<b>Start</b>	*NR1*
	<b>QC:</b> _____	<b>Date:</b> _____	<b>SPC (Y/N):</b> _____	<b>Date:</b> _____	<b>Stop</b>		*NR2*

<b>Sequence ID/ Work Center ID</b>	<b>Operation Description</b>	<b>Set Up/ Run Hours</b>	<b>Tool ID</b>	<b>Tool #</b>	<b>Plan Code</b>	<b>Accept Qty</b>	<b>Reject Qty</b>	<b>Reject Number</b>	<b>Insp. Stamp</b>
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130

\*130\*

Powdercoat

Powder Coating

White Gloss(Ref 4.3.5.2) per QSJ005 4.3-Steel  
Blade Standex

Memo

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME: 2:00

OVEN TEMPERATURE: 320

FINISH TIME: 2:30

\*\*\*\*\*2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

m123480

140

QC3- Inspect Part Finish

\*140\*

QC

Quality Control

Memo

0.00

0.00

1X8 m-f 13/05/27

10 13-5-27



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**Work Order ID:** 101981

**Parent Item:** D3913-041

**Parent Item Name:** Long Basket Base Assembly, 350

**Start Date:** 5/22/13

**Required Date:** 6/06/13

**Start Qty:** 1.00

**Required Qty:** 1.00

**Comments:** IPP Rev:A new issue DD 10.03.19 verified by:EC  
verified by:EC

IPP Rev:B chg qty's DD 10.04.12  
IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-10A Bolt		Purchased	No			150	Each	79.0000	6	6		BK 13-5-27	
					<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
					GA		22						
					122800		22						
					ST351		4						
					12422		3						
					124858		1						
					ST512		53						
					122800		53						
AN960JD8 Washer	NAS1149DN832J	Purchased	No			150	Each	0.0000	2	2		BK 13-5-27	
D2581 Mounting Bracket		Manufactured	No			100	Each	66.0000	2	2		B98503 → 2	
					<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
					WA		10						
					98503		10						
					WA004		56						
					101383		20						
					70766		2						
					81253		1						
					82506		2						
					83230		3						
					85452		2						
					87706		2						
					99067		12						
					99837		12						

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**Work Order ID:** 101981

**Parent Item:** D3913-041

**Parent Item Name:** Long Basket Base Assemby, 350

**Start Date:** 5/22/13

**Required Date:** 6/06/13

**Start Qty:** 1.00

**Required Qty:** 1.00

D2931

Manufactured

No

150

Each

2,190.0000

2

2

BL 13-5-27

Bumper

Location

GA

Loc Qty

192

46064

192

ST021

1998

86435

1998

D3913-1

Manufactured

No

100

Each

2.0000

1

B 94721 M 13.05.24

Rib

Location

WA005

Loc Qty

2

88637

2

D3913-15

Wide Handle Plate

Manufactured

No

100

Each

17.0000

1

B 100417 M 13.05.24

Location

WA003

Loc Qty

12

100417

12

WA004

5

97719

5

D3913-3

Rib

Manufactured

No

100

Each

7.0000

1

B 97973 M 13.05.24

Location

WA004

Loc Qty

5

97728

2

97973

3

WA005

2

69160

1

84651

1

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**Start Date:** 5/22/13

**Required Date:** 6/06/13

**Start Qty:** 1.00

**Required Qty:** 1.00

D3913-7

Manufactured

No

100 Each 6.0000

2

B94742 → 2x

SJ 13.05.24

D3913-9

Hinge Rib

Manufactured

No

100 Each 5.0000

1

B97674 → 1x

SJ 13.05.24

D3916-041

Rib Assembly

Manufactured

No

100 Each 8.0000

2

B97938 → 2x

SJ 13.05.24

D3916-5

Light Rib

Manufactured

No

100 Each 16.0000

3

B97725 → 3x

SJ 13.05.24

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**Work Order ID:** 101981

**Parent Item:** D3913-041

**Parent Item Name:** Long Basket Base Assemby, 350

**Start Date:** 5/22/13

**Required Date:** 6/06/13

**Start Qty:** 1.00

**Required Qty:** 1.00

**D4016-1**  
Hinge Half, Base

Manufactured

No

100 Each 52.0000

3

3

B97664 → 3x

My 13.05.24

<u>Location</u>	
WA	11
97664	11
WA004	30
100265	30
WA005	11
94481	11

<u>Loc Qty</u>	<u>Loc Code</u>
11	
11	
30	
30	
11	
11	

**D4017-7**  
Rib

Manufactured

No

100 Each 7.0000

1

1

B94149 My 13.05.24

<u>Location</u>	
WA004	3
94149	3
WA005	4
69730	1
82969	1
85435	1
88392	1

<u>Loc Qty</u>	<u>Loc Code</u>
3	
3	
4	
1	
1	
1	
1	

**D4017-9**  
Rib

Manufactured

No

100 Each 7.0000

2

2

B98002 → 2x

My 13.05.24

<u>Location</u>	
WA004	4
98002	4
WA005	3
70341	2
81445	1

<u>Loc Qty</u>	<u>Loc Code</u>
4	
4	
3	
2	
1	

**D4020-11**  
End Mesh, Basket

Manufactured

No

100 Each 11.0000

2

2

B100650 My 13.05.24

<u>Location</u>	
WA007	11
100650	8
81442	2
84972	1

<u>Loc Qty</u>	<u>Loc Code</u>
11	
8	
2	
1	

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**Work Order ID:** 101981

**Parent Item:** D3913-041

**Parent Item Name:** Long Basket Base Assemby, 350.

**Start Date:** 5/22/13

**Required Date:** 6/06/13

**Start Qty:** 1.00

**Required Qty:** 1.00

**D4021-1**  
Handle Plate

Manufactured

No

100 Each 81.0000

3

B100649<sup>3</sup> → 3x  
M/13-05-24

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA004	81	
100366	54	
100649	19	
89204	3	
94596	3	
97940	2	

**D4021-5**  
Blanking Plate

Manufactured

No

150 Each 10.0000

2

2

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST084	10	
85065	2	
98260	8	

**D4034-041**  
Aft Upper Rib Assembly

Manufactured

No

100 Each 5.0000

1

B94813 M/13-05-24

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA004	4	
94813	3	
94977	1	
WA005	1	
84048	1	

**D4034-043**  
Fwd Upper Rib Assembly

Manufactured

No

100 Each 5.0000

1

B99595

M/13-05-24

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA004	3	
100286	1	
99595	2	
WA005	2	
82980	2	

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**Work Order ID:** 101981

**Parent Item:** D3913-041

**Parent Item Name:** Long Basket Base Assemby, 350

**Start Date:** 5/22/13

**Required Date:** 6/06/13

D4672-1  
Blanking Plate

Manufactured

No

100 Each 22.0000

2

B 101186 → 2

13.05.24

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA004	18	
101186	18	
WA005	4	
88253	4	

M304EX0.75-16F  
Expanded Metal Flat SS

Purchased

No

100 sf 1,355.8151

33

1125457 → 33

13.05.24

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	176.2791180	
125113	176.279118	
WA	447	
125457	447	
WA007	732.536	
123448	15.96	
125457	236.576	
125605	480	

MS20600-AD4W3  
Cherry Rivets

Purchased

No

150 Each 1,121.0000

2

BL B502

13.05.24

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST311	988	
122151	4	
122452	4	
123525	294	
124231	686	2
WA003	133	
107939	133	

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Work Order ID: 101981

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/22/13

Required Date: 6/06/13

MS21042L3

Purchased

No

150

Each

3,595.0000

6

6

BL 13-5-27

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	3	
122141	3	
GA	18	
122452	18	
ST314	268	
117885	32	
119017	55	
119075	138	
123265	43	
ST506	3306	
123900	954	
124291	2352	

NAS1149F0332P

WASHER

Purchased

No

150

Each

13,046.000

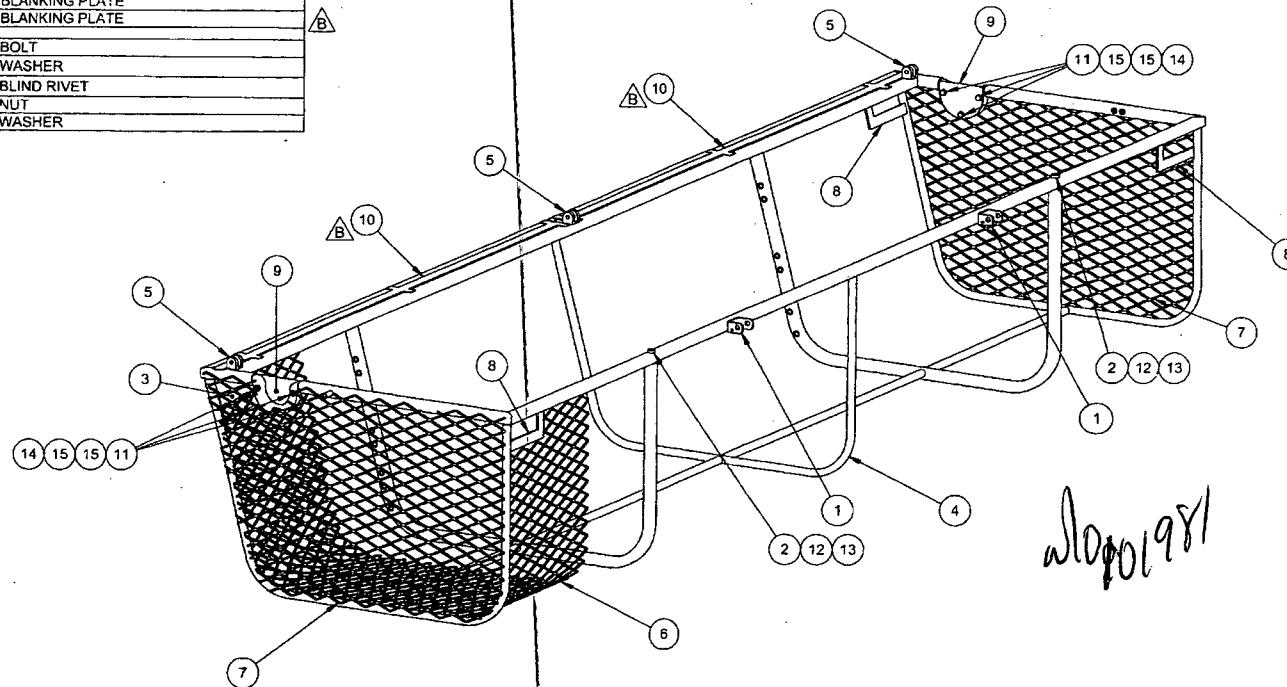
12

12

BL B5-27.

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	182	
122063	182	
ST294	158	
122063	158	
ST295	3	
123352	3	
st510	7703	
123900	7703	
ST510a	5000	
125646	5000	

ITEM	QTY	P/N	DESCRIPTION
	8	X D3913-041	LONG BASKET BASE ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
3	1	D3913-15	WIDE HANDLE PLATE
4	1	D3913-101	TUBULAR ASSY (350 LONG BASKET)
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-1	BLANKING PLATE
11	6	AN3-10A	BOLT
12	2	AN960JDB	WASHER
13	2	MS20600AD4W3	BLIND RIVET
14	6	MS21042L3	NUT
15	12	NAS1149F0332P	WASHER



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: NONE  
 7) WEIGHT: 43.9 lbs APPROX  
 8) INSTALL AFTER FINISH  
 9) MASK HOLES PRIOR TO POWDER COAT  
 10) WELD PER DART QSI 004

RELEASED  
2012-07-12  
IP ECN 12-6\*

B	ADD D4672-1 (ZN C4-1, C6-1, D2-2, D2-3, & D5-2), REASON: PART2-197.	MB	12.06.15
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RJS	DART AEROSPACE LTD	
DRAWN	A.P.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.		D3913	SHEET 1 OF 6
APPROVED	L.W.D.	TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
DATE	12.06.15	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

